

Work Order ID 83680 -2

83680

Page 1

Monday, April 23, 2012 12:56:14 PM

Item ID: D4016-3

Revision ID:

Item Name: Hinge Half, Lid

Start Date: 4/23/2012 Start Qty: 18.00

Required Date: 4/30/2012 Req'd Qty: 18.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

split
18 *18*
18 *18*

Approvals: Process Plan:

QC:

Date: 1204-23 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4016

A

100

Cut blanks as per folio

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK as per folio

0.00

OK 12/05/22

13

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA874 AND DWG

FOLIO REV: *AA*

DWG REV: *A*

0.00

OK 12/05/22

13

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83680

83680

Page 2

Monday, April 23, 2012 12:56:14 PM

Item ID: D4016-3 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hinge Half, Lid
 Start Date: 4/23/2012 Start Qty: 18.00 *18* Cust Item ID:
 Required Date: 4/30/2012 Req'd Qty: 18.00 *18* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		OK 12/05/22		13	*		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		JL 12-05-22		(13)			
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00				13x			Pl 12.05.29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 83680

Monday, April 23, 2012 12:56:14 PM

83680

Page 3

Item ID: D4016-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Half, Lid

Start Date: 4/23/2012 Start Qty: 18.00

18

Cust Item ID:

Required Date: 4/30/2012 Req'd Qty: 18.00

18

Customer:

Reference:

Run Start ***NR1***

Stop ***NR2***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/5/30 *[Signature]*

WLF
12-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 23, 2012 12:56:19 PM

Page 1

Work Order ID: 83680

83680

Parent Item: D4016-3

D4016-3

Parent Item Name: Hinge Half, Lid

Start Date: 4/23/2012

Required Date: 4/30/2012

Start Qty: 18.00

Required Qty: 18.00

Comments: I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	1.0470	0.08	1.515789			

M304B1 000X1 000

**

304 bar 1.00 x 1.00

Location

Loc Qty

Loc Code

MAT050

1.047

113290

1.047

304 1.50 X 1.50 M116719 X 1.18 ank 12/05/22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Proc Mgr	Approval QC Inspector

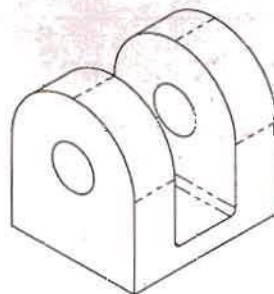
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

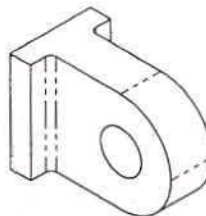
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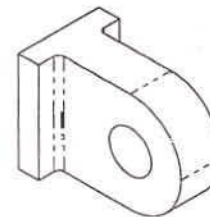
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83680 *PL 12 04 29*



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

RELEASED
2010-02-16
MD

A	NEW ISSUE	JPH	10.01.29
REV	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
DATE	10.01.29	<small>COPYRIGHT ©2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED. NO DISSEMINATION OF THIS DOCUMENT OR CONTENT IT IS NOT TO BE USED FOR ANY PURPOSES - A COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

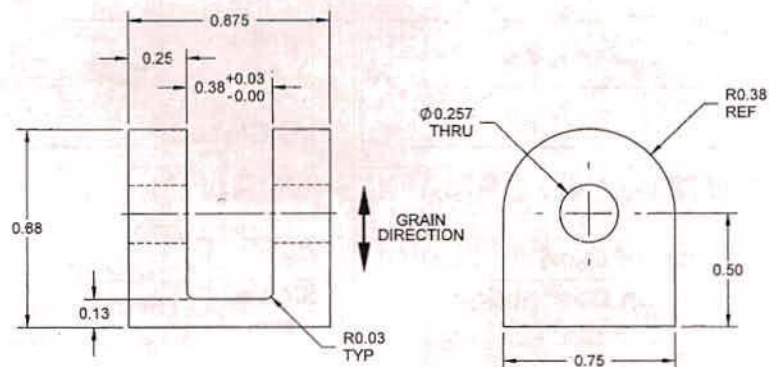
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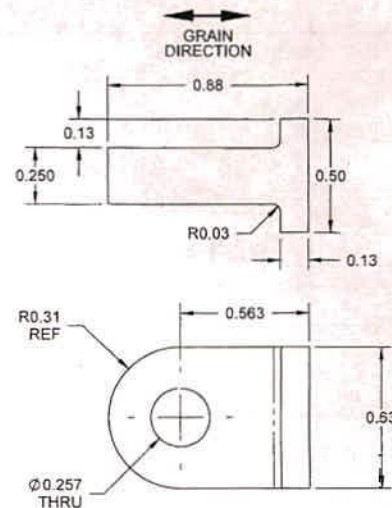
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL: -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG APPR.	<i>[Signature]</i>	D4016	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
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